

Date: Monday, 6/5/2006 11:03:09 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LONG STEP ASSEMBLY HIGH SKID RH
Job Number : 27425	
Estimate Number : 10274	
P.O. Number : N/A	Part Number : D350591312
This Issue : 6/5/2006 S.O. No. : N/A	Drawing Number : D3272 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 27140	Material : N/A
Written By : <i>See Comment Below</i>	Due Date : 7/20/2006 Qty: 10 Um: Each
Checked & Approved By : <i>KJ 06.06.05</i>	
Comment : Est Rev: A 04.03.22 New issue KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

06.06.28

KS

2.0	D2622120C	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2622-120 Extrusion B27077

FF 06.07.10 10

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A

FF 06.07.10 10

2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.

L.E. 06.07.11 10

3-Deburr

L.E. 06.07.11 10

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

5.0	D30671	End Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

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Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 D3067-1

End Plate

B 27591

LE 06.07.11

10

6.0

D32191

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3219-1

Support

B 27150

LE 06.07.11

10

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY

LE 06.07.11

10

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod *M100660*

LE 06.07.12

10

3-Grind End Plate flush

M15689

LE 06.07.12

10

8.0

QC5/9

WELD INSPECTION



Comment: Inspect weld and work to Step 9

PD 06-07-13

PD 06-07-14

(10)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06.07.14

10

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PD 06-07-14

(10)

11.0

D3065041

Step Leg Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3065-041

Step Leg Assy

B 26928

FF 06-07-10

10

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 27425

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D30661

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3066-1

Spacer

B27526

FF 06-07-18

20

13.0

MS20600AD4W4

Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 MS20600AD4W4

Rivet

1719085

= 160

FF 06-07-18

10

14.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble Leg Assembly as per Dwg D3272.

FF 06-07-18

PTO

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 06-07-18

10

16.0

D30671

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3067-1

End Plate

B27591

FF 06-07-18

10

17.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 024

3-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod m15689

FF 06-07-18

10

FF 06-07-18

10

FF 06-07-18

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06-07-18	14						

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-07-18	14	Rivets not good (stem broke early inside rivet head)	<i>[Signature]</i> 06-07-18	Rework old rivets out and put new rivets in	<i>[Signature]</i> 06-07-18	<i>[Signature]</i> 06-07-18	<i>[Signature]</i> 06-07-18	<i>[Signature]</i> 06-07-18

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *[Signature]* Date: 06/07/18

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 27425

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description:

4-Grind End Plate flush

LL 06-07-19

18.0

QC5/9

WELD INSPECTION



Comment: Inspect work & Weld to Current - Check dimension 108.93" & 3.375" as per Dwg D3272

QC5/9 -> PD 06-07-19

19.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

FF 06-07-19

20.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-07-20

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3272 and QSI 005 4.4

a.m 06-07-20

22.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

24.0

D22303

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2230-3 Mounting Lug

B27579 V

25.0

D2618

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2618

Bushing

B27144 V

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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NOTE: Date & initial all entries

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Process Sheet

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Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 27425

Part Number: D350591312

Job Number:



Seq. #:	Machine Or Operation:	Description :
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26.0	D2856400	Abrasion Strip
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Comment: Qty.: 0.6000 f(s)/Unit Total : 6.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2856-400-720 Abrasion Strip B27545 ✓

27.0	D32351	Mounting Lug
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D3235-1 Mounting Lug B24567 ✓

28.0	D3278041	Support Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3278-041 Support Assembly B24568 x 2 ✓ B27593 x 8 ✓

29.0	AN335A	Bolt
------	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN3-35A Bolt M19551 ✓

30.0	AN413A	Bolt
------	--------	------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN4-13A Bolt M19149 ✓

31.0	AN536A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN5-36A Bolt M18428 ✓

W/O:		WORK ORDER CHANGES					
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Job Number: 27425

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10

Washer

M100713 ✓

33.0

AN960JD416

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 AN960JD416

Washer

M101369 ✓

34.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD516

Washer

M101369 ✓

35.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L3

Nut (or -3)

M100094 ✓

36.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4

Nut (or -4)

M19005 ✓

W/O:		WORK ORDER CHANGES					
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Job Number: 27425

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

37.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L5

Nut (or -5)

177694 ✓

AL 06/07/24 (10)

38.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AL 06/7/25 (10)

39.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-311

Location:

Rose. B

AL 06/07/25 (10)

40.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

AL 06/07/25 (18)

Job Completion



AL 06.07.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3272	REV. A SHEET 1 OF 2
DATE 04.03.01		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	

RELEASED
04.04.05 *#*

Part No.	Description	QTY -041	QTY -042
D3272-041	Step Assembly, High Long (LH)	X	
D3272-042	Step Assembly, High Long (RH)		X
D2622-120	STEP EXTRUSION	1	1
D3219-1	SUPPORT	2	2
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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WORK ORDER
NO. 27425

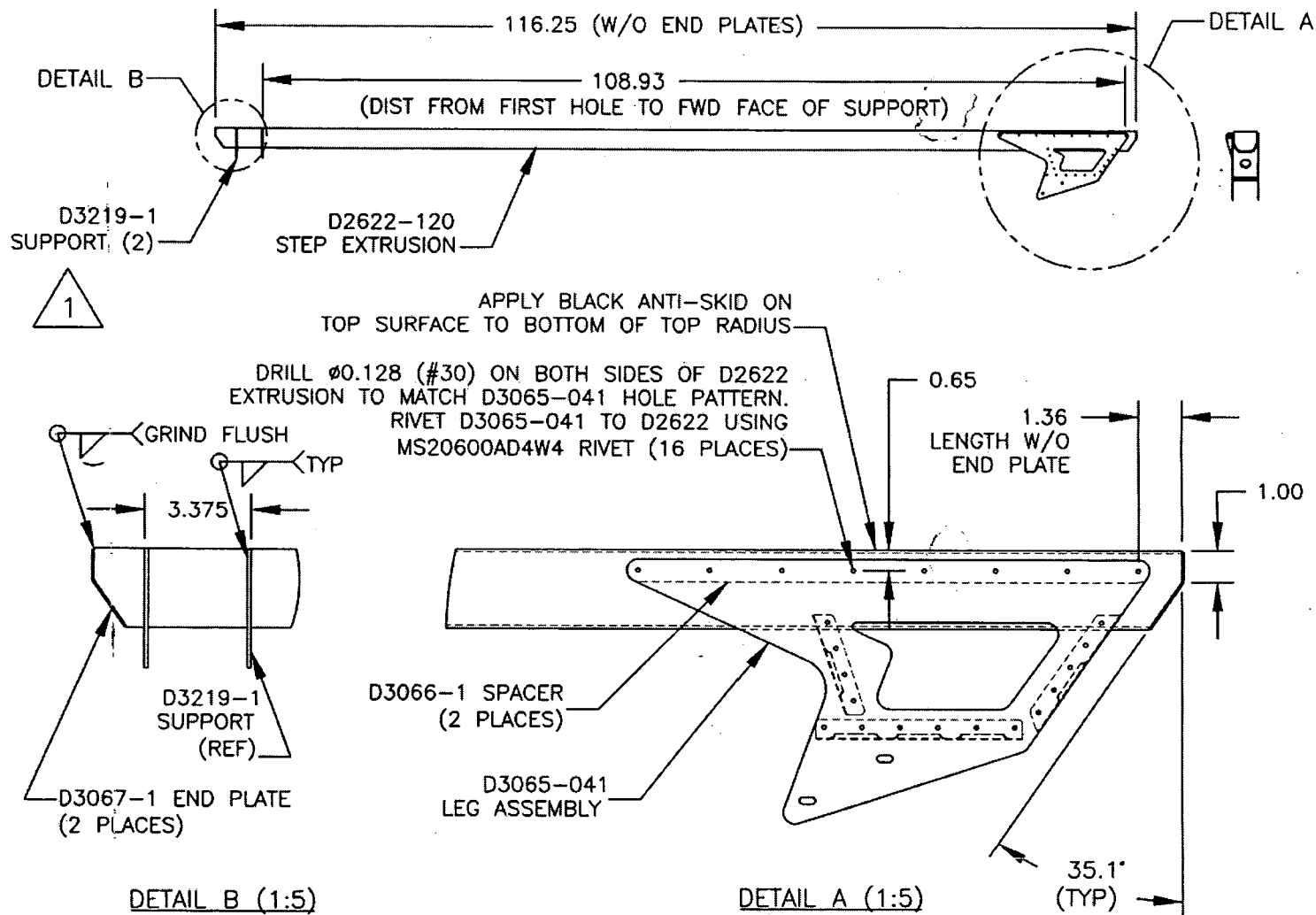
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DART



DESIGN	APPROVED	DRAWN BY	APPROVED	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	D3272	REV. A	
DATE	04.03.01	TITLE	STEP ASSEMBLY, HI LONG	SHEET 2 OF 2	SCALE 1:20



DETAIL B (1:5)

DETAIL A (1:5)

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